



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBIR7028
Job Sheet 196183



Part No: RBIR7028

Job Qty: 2 pcs

Part Name: Swashplate Bearing Install and Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/7/19

Job Tracking No:

Due Date: 7/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 16967

Note: DWG RBIR7### Rev. 0 IPP Rev. A 18.06.04 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	7/23/19		0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	7/23/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
130	Packaging 3-1 - Stock - B4B	2 pcs	7/23/19		0.00	0.00	QC 5 - 9		JUL 24 2019 409-89
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S200163



Part: RBIR7028

Job No: 196183

Serial No/Batch: S200163

Revision: 0

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/24/19

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				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	2 pcs	7/23/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

DAS
70
9-89

Part Op 110 - (Small Fab) 1-Assemble as per DWG.
 Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)
 130 - Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90477A030	Rotating Flange Nut	2 Ea (1 ea)	110-Small Fab - 1	5079292
92865A597	Medium-Strength Grade 5 Steel Hex Head Screw	2 Ea (1 ea)	110-Small Fab - 1	5079293
97416A123	Black-Oxide Steel SAE Washer	4 Ea (2 ea)	110-Small Fab - 1	5079294
RBIR7028-1	Receiver	2 pcs (1 ea)	110-Small Fab - 1	5195624
RBIR7028-3	Remover / Installer	2 pcs (1 ea)	110-Small Fab - 1	5195276
RBIR7028-5	Alignment Seat	2 pcs (1 ea)	110-Small Fab - 1	5195651

Job Allocations

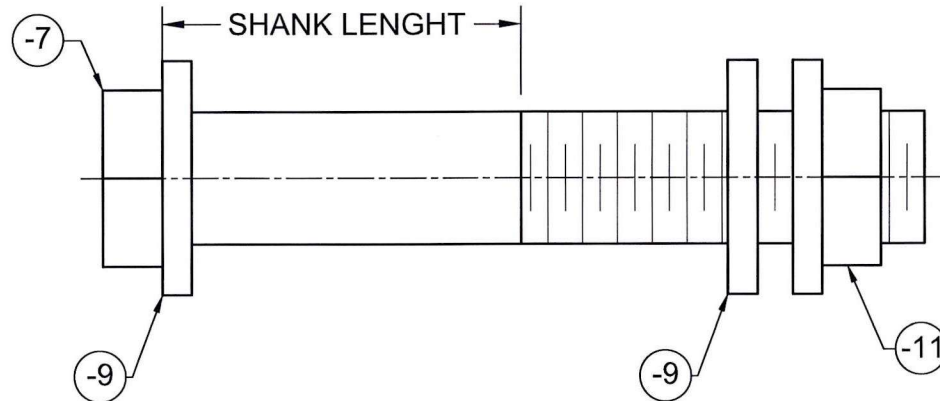
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	90477A030	2	4	0
	92865A597	2	4	0
	97416A123	4	88	0
	RBIR7028-1	2	9	0
	RBIR7028-3	2	11	0
	RBIR7028-5	2	9	0

Part Specifications

Specifications could not be found.

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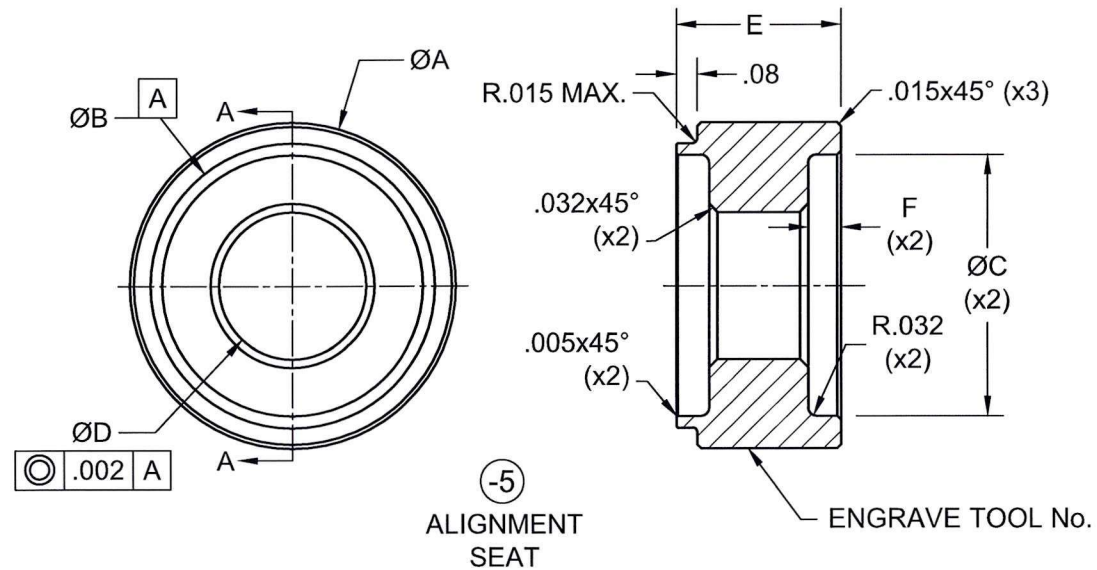
REV		REVISIONS			DATE	INITIAL	APPROVED
-	-				-	-	



TOOL #	BRG. ID.	-7 HEX HEAD CAP SCREW (QTY. 1)				-9 MACH. WASHER		-11 NUT (QTY. 1)	
		SCREW SIZE	SHANK LENGTH	MAT.	QTY.	TYPE		TYPE	
KIR4103-7	.3125	5/16-18 UNC x 3-3/8	3/4 or less	GR. 8	2	Ø5/16 ID.		5/16-18 UNC SW. FLG. NUT MCMASTER-CAR #90477A030	

 RED BARN MACHINE	
TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS; HARDWARE	
DWG NO. CHARTED TOOL No. -7, 9, & 11	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-22-10
SHEET 5 of 5	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC ALL BLACK OXIDE USED ON BEARING	

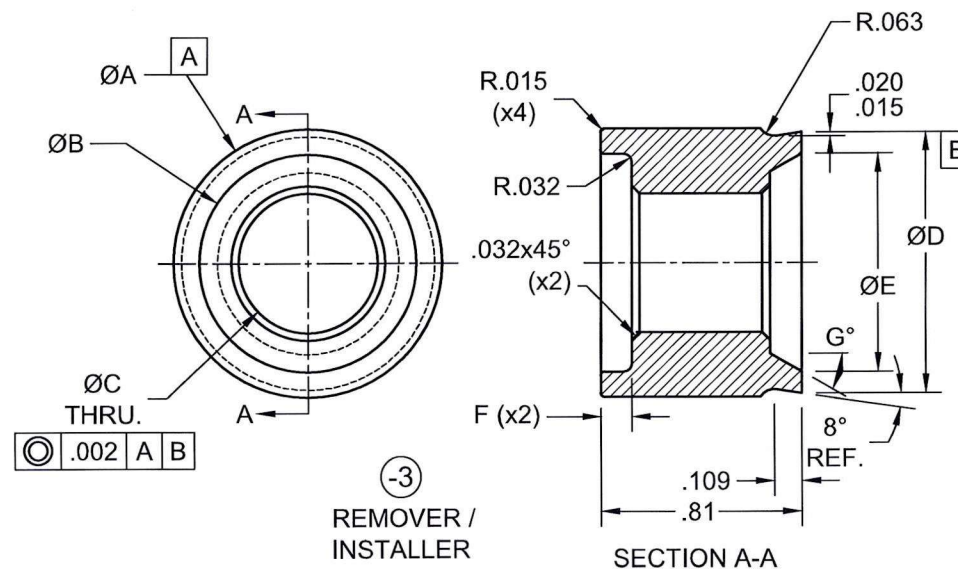
REV		DESCRIPTION	REVISIONS		
DATE	INITIAL	APPROVED			
-	-	-			



TOOL #	BRG. OD.	ØA +.000 -.010	ØB +.001 -.003	ØC +.000 -.010	ØD +.003 -.000	E +.010 -.010	F +.010 -.010	MATERIAL	SPECIFICATIONS
KIR4103-7	.9375	1.188	.929	.798	.313	.804	.270	4140 Q&T	Ø1-1/4 x 7/8

RED BARN MACHINE	
TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS; ALIGNMENT SEAT	
DWG NO. CHARTED TOOL No. -5	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE CHART
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-22-10 SHEET 4 of 5

REVISIONS				DATE	INITIAL	APPROVED
REV	DESCRIPTION					
-				-	-	

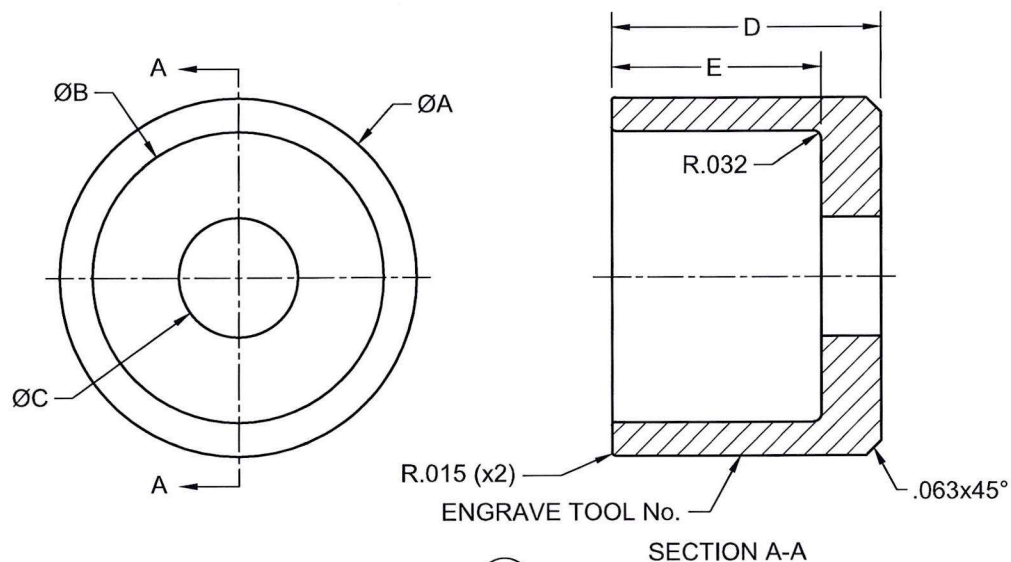


TOOL #	BRG. OD.	ØA +.000 -.004	ØB +.005 -.005	ØC +.003 -.000	ØD +.003 -.003	ØE +.003 -.003	F +.010 -.010	G° +.5 -.5	MATERIAL	SPECIFICATIONS
RBIR7028	.9375	.929	.797	.313	.890	.787	.270	25°	4140 Q&T	Ø1 x 1

RED BARN MACHINE	
TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS; REMOVER/INSTALLER	
DWG NO. CHARTED TOOL No. -3	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± .5° .XX ± .01 .X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT	APPROVED
HEAT TREAT	FINISH SPEC
BLACK OXIDE	
USED ON BEARING	
SEE CHART	
SCALE NTS	DATE 10-22-10 SHEET 3 of 5

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REV	DESCRIPTION	REVISIONS		
		DATE	INITIAL	APPROVED
-	-	-	-	-



-1

RECEIVER

TOOL #	ØA +.010 -.010	ØB +.005 -.005	ØC +.005 -.000	D +.010 -.010	E +.010 -.010	MATERIAL	SPECIFICATIONS
RBIR7028	1.375	1.038	.313	1.312	1.062	1018	Ø1-3/8 x 1-1/8

RED BARN MACHINE	
TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS; RECIEVER	
DWG NO. CHARTED TOOL No. -1	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: PERRITT
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	APPROVED
FRACTIONS ± 1/32 ANGLES ± 5°	HEAT TREAT FINISH SPEC BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING SEE CHART
SCALE NTS	DATE 10-22-10 SHEET 2 of 5

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	RECEIVER		SEE CHART	2
			-3	1	REMOVER / INSTALLER		SEE CHART	3
			-5	1	ALIGNMENT SEAT		SEE CHART	4
		B/O	-7	1	HEX HEAD CAP SCREW		SEE CHART	5
		B/O	-9	SEE CHART	MACHINE WASHER		SEE CHART	5
		B/O	-11	1	NUT		SEE CHART	5
	ASSY #							

 RED BARN MACHINE	
TITLE PORTABLE BEARING INSTALL & REMOVAL TOOLS	
DWG NO. SEE CHART FOR TOOL No.	REV -
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: PERRITT APPROVED <i>D Weid</i> HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE CHART ABOVE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° R .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-22-10
	SHEET 1 of 5